

Appl. No. 10/004,510  
Amdt. dated Sept. 9, 2004  
Reply to Office action of March 9, 2004

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claims 1-8 (Canceled).

Claim 9 (Previously Presented): A method for producing die-cut business forms, said method comprising the steps of:

providing a continuous web of stock paper;

extending the web through at least a first printing station for printing on selected areas of the web;

extending the web from the at least first printing station through an adhesive patch station for applying adhesive to selected areas of either one or both of the web or patch material to form an adhesive patch with selected areas of the web, the adhesive patch station having a supply of patch material and an applicator to apply the adhesive to the selected areas of either one or both of the web and patch material to apply the patch material to the selected areas of the web; and

extending the web from the adhesive patch station through at least one die cutting station for cutting selected portion of the web with die cuts and at least a second printing station for printing on selected areas of one or both of the web or patch material.

Claim 10 (Canceled).

Claim 11 (Previously Presented): The method of Claim 9 wherein the patch material comprises glassine paper.

Claim 12 (Previously Presented): A method for producing die-cut business forms, said method comprising the steps of:

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providing a continuous web of stock paper;  
extending the web through at least a first printing station;  
printing on selected areas of the web with the at least first printing station;  
extending the web from the at least one printing station through an adhesive patch station, the adhesive patch station having a supply of patch material and an applicator operatively coupled with the supply of patch material so as to apply adhesive to selected areas of either one or both of the web and patch material to apply the patch material to the selected areas of the web;  
applying an adhesive patch to selected areas of the web by applying the adhesive to the selected areas of either one or both of the web and patch material with the adhesive patch station;  
extending the web from the adhesive patch station through at least one die cutting station;  
cutting selected portions of the web contiguous with the adhesive patch with die cuts with the at least one die cutting station;  
extending the web from the adhesive patch station through at least a second printing station; and  
printing on selected areas of either one or both of the web and patch material with the at least second printing station.

Claim 13 (Canceled).

Claim 14 (Previously Presented): The method of Claim 12 wherein the patch material comprises glassine paper.

Claim 15 (Previously Presented): A method for producing printed business forms with at least one integrated, removable portion on a press from a source of stock paper comprising:

supplying a roll of stock paper at a supply station;

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unwinding the roll of stock paper to supply a continuous web of paper to run through the press;

receiving the continuous web of paper by at least a first printing press station;

printing indicia on at least a first selected area of the continuous web of paper as the at least first selected area of the continuous web of paper passes through the at least first printing press station;

receiving the continuous web of paper by at least one adhesive patch station;

applying adhesive to a second selected area of either one or both of the continuous web of paper and patch material and applying selected areas of the patch material to selected areas of the web by the at least one adhesive patch station;

receiving the continuous web of paper from the at least one adhesive patch station by at least a second printing press station;

printing indicia on at least a first selected area of the continuous web of paper as the at least first selected area of the continuous web of paper passes through the at least second printing press station;

receiving the continuous web of paper by at least one die cutting station;

die cutting at least a third selected area of the continuous web of paper, the at least third selected area being contiguous with the patch material as the continuous web of paper pass through the at least one die cutting station in order to produce a removable portion of the continuous web of paper to form business forms with at least one removable, integrated portion;

receiving the continuous web of paper by at least one punch station;

removing a selected area of the business form as the continuous web passes through the at least one punch station; and

receiving the continuous web of paper by at least one finishing station to process the continuous web into a preselected output configuration for the business forms.

Claim 16 (Canceled).

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**Claim 17 (New): A method for producing die-cut business forms in accordance with claim 9, wherein the selected portions of the web that are die cut using the at least one die cutting station are contiguous with the patch material.**